Work Order ID 74136

Monday, September 26, 2011 8:44:22 AM

Item ID: D2576-3
Revision ID:
Item Name: Step (maching detail)
Start Date: 9/26/2011 **Start Qty:** 50.00
Required Date: 9/30/2011 **Req'd Qty:** 50.00
Reference:

Accept **Setup Start** **Stop**

Cust Item ID:
Customer:

Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp.

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Run Start **Stop**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2576	Rev G								
100 HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 **Memo** HAAS 1 1- Machine as per Folio FA332 and Dwg D2576 2- Deburr	0.00 0.00				50	0		
110 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00				50	0		
120 QC Quality Control	QC8- Inspect parts - second check **Memo**	0.00 0.00				50	0		

Picklist Print

Monday, September 26, 2011 8:44:18 AM

Work Order ID: 74136

Parent Item: D2576-3

Parent Item Name: Step (maching detail)

Start Date: 9/26/2011 **Required Date:** 9/30/2011

Start Qty: 50.00 **Required Qty:** 50.00

Comments: IPP: E □02.08.19□Consolidated D2576-1 and D2576-3□ KJ/RF

IPP Rev:D As per Rev G 07-09-05 JLM Verified By:EC□

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2576-1		Manufactured	No			100	Each	0.0000	1	50			
Step (casting detail)													

73293 x50 11.09.26.

DART AEROSPACE LTD	Work Order:	74136
Description: Step	Part Number:	D2576-3
Inspection Dwg: D2576 Rev: G		Page 1 of 1

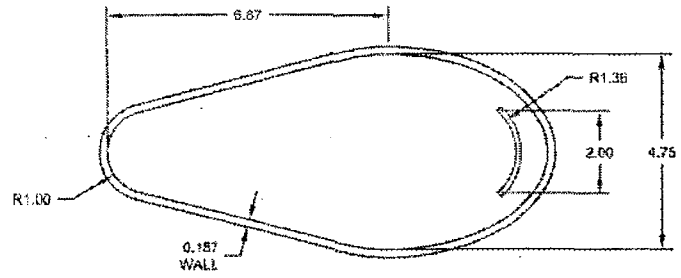
FIRST ARTICLE INSPECTION CHECKLIST

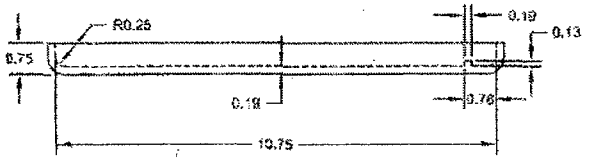
[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
7.50	+/-0.030	7.525			CNC02 Vern.	
Slot 0.250 x 1.25	+/-0.030	.248 x 1.25			"	
Slot 0.250 x 0.65	+/-0.030	.248 x .65			"	
Slot 0.250 x 1.28	+/-0.030	.248 x 1.28			"	
0.19	+/-0.030	.199			31006 Height gauge.	
0.13	+/-0.030	.13			"	
0.063	+/-0.010	.063			EC-8 Vern.	

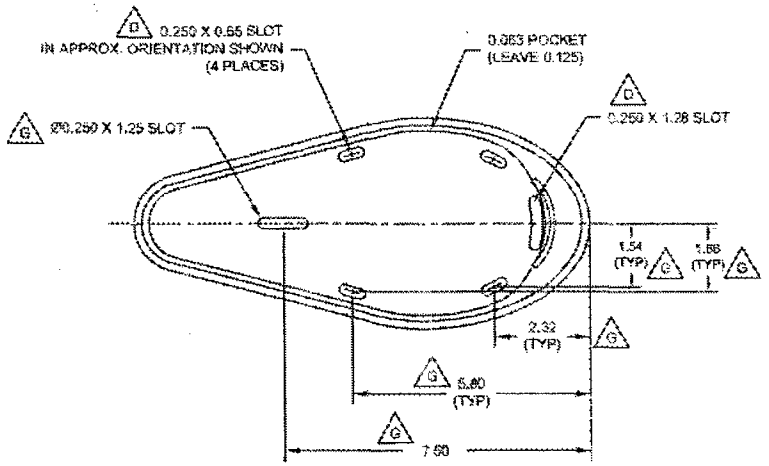
Measured by:	RR FK	Audited by:	JL	Prototype Approval:	N/A
Date:	11/09/26	Date:	11/09/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF	
B	07.09.06	Dimensions updated per Dwg Rev G	KJ/JLM	EE





D2576-1 CASTING



D2576-3 MACHINING DETAIL
(MAKE FROM D2575-1)

NOTES:
1) MATERIAL: CAST ALUMINUM ALLOY A-535.2
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.025 TO 0.050 MAX
6) IDENTIFICATION: NONE

96/24 o/m

RELEASED
07.08.29

REV.	DESCRIPTION	BY	DATE
G	- CHANGE SLOTS LOCATION AND SIZE ON D2576-3 - DUE TO SKID BENDING PROGRAM CHANGES - UPDATE CNC PROGRAM	MB	07.08.15
F	7.05 WAS 5.81	PH	07.04.17
E	CHANGE 6.50 HOLE LOCATION AND ADD NOTE	RF	99.08.07
D	CHANGE SLOT SIZE AND LOCATION (TSR A1069)	GP	98.08.18
C	ADD POCKETS AND SLOTS FOR WELDING	DS	98.08.18
B	REMOVE POCKETS, ADD HOLE	DS	96.11.28
A	NEW ISSUE	DS	96.09.18

DESIGN	**DART AEROSPACE LTD**	
DRAWN	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DRAWING NO.	REV. G
MFG. APPR.	D2575	SHEET 1 OF 1
APPROVED	TITLE	SCALE
DE APPR.	STEP	1:3
DATE 07.08.15	COPYRIGHT © 1998 BY DART AEROSPACE LTD	